



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3610-041
Job Sheet 175518



Part No: D3610-041

Job Qty: 8 ea

Part Name: Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/6/18

Job Tracking No:

Due Date: 4/17/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG D3610 REV B IPP rev A new issue 07.03.28 EC IPP rev B released, changed mat'l EC IPP REV C:AS
PER REV B JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea	4/17/18	4/17/18	0.00	0.00	Start Up Machining-2		DAS 18/04/28
100	Bandsaw	8 pcs	4/17/18	4/17/18	0.00	0.28	Bandsaw1		52 18/04/28
110	CNC Vertical Machining	8 pcs	4/17/18	4/17/18	0.39	9.76	HAAS1-4		9-89 18/04/28
120	QC	8 pcs	4/17/18	4/17/18	0.00	0.00	QC2 Machining-2		18/04/28
130	QC	8 pcs	4/17/18	4/17/18	0.00	0.00	QC8 Machining-2		9-89 18/04/28
140	Small Fab	8 pcs	4/17/18	4/17/18	0.00	0.33	Small Fab-4		JAS 38
150	QC	8 pcs	4/17/18	4/17/18	0.00	0.00	QC5		38
160	Powdercoat	8 pcs	4/17/18	4/17/18	0.00	0.15	Powdercoat3		3-89 5-02
170	QC	8 pcs	4/17/18	4/17/18	0.00	0.00	QC3		DAS 38
180	Small Fab	8 pcs	4/17/18	4/17/18	0.00	0.33	Small Fab-4		3-89
190	QC	8 pcs	4/17/18	4/17/18	0.00	0.00	QC5		DAS 21
200	Packaging	8 pcs	4/17/18	4/17/18	0.00	0.00	Packaging3-1		3-89
210	QC21-SA	8 Ea	4/17/18	4/17/18	0.00	0.00	QC21		3-89

Part Op 100 - Cut blank 7.900 " long

Descriptions: 110 - 1- Mill as per Folio FA692 Rev: _____ & Dwg D3610 Rev: _____ 2-Deburr per dwg D3610

140 - 1-C'SINK AS PER DWG D3610

160 - START TIME: 9:15 OVEN TEMPERATURE: 300 FINISH TIME: 9:45

180 - Rivet Nut Plate as per Dwg D3610

MAY 02 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M4140N-B1.500X1.5000	4140 Steel Bar 1.50 X 1.50	5.6000 ft (.7 ea)	90-Start up Operation	
MS20426AD3-4	Rivet	16 Ea (2 ea)	90-Start up Operation	FA134294
MS21075L3	Nut Plate	8 Ea (1 ea)	90-Start up Operation	FA134294

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M4140N-B1.500X1.5000	6	30	0
	MS20426AD3-4	16	3,660	0
	MS21075L3	8	873	0

506623

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval					
Description Work Order Deviation		Disposition							
		Completed By							
		Lead hand / Supervisor Approval Verification							
		Coordinator Approval							
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%; vertical-align: top;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%; vertical-align: top;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	<table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%; vertical-align: top;"> Pressure/F ☐ Bending ☐ Centre No ☐ Cracks ☐ Crimp/Ki ☐ Cuffs ☐ Crushing ☐ Heat Tr ☐ Wave/ ☐ Marks/Chatter ☐ </td> <td style="width:50%; vertical-align: top;"> OTHER : ☐ </td> </tr> </table>				Pressure/F ☐ Bending ☐ Centre No ☐ Cracks ☐ Crimp/Ki ☐ Cuffs ☐ Crushing ☐ Heat Tr ☐ Wave/ ☐ Marks/Chatter ☐	OTHER : ☐
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Container No: S066627



Part: D3610-041

Job No: 175518

Serial No/Batch: S066627

Revision: B

Inspector:

Date: 04/28/18

oned Wrong
 le Dimensions
 'Under tolerance
 Incorrect
 Lost/Missing
 Moved
 wing
 ish
 spread
 rning Sequence

Part Specifications
Specifications could not be found.

Plex 4/24/18 3:21 PM dart.lacelle.linda

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

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Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								